



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G01232-3G-PO

Job Sheet 187033



Part No: RBW6305G01232-3G-PO **Job Qty:** 1 pcs

Part Name: Gimbal Torque Tube Bushing Remover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/26/18

Job Tracking No:

Due Date: 12/14/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB 92700-10301-041 Rev.A IPP Rev. A 18.11.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	1 pcs	12/14/18	12/14/18	0.00	0.00	Purchasing - 1	<i>[Signature]</i>
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging 2 - 1 - B4B	<i>[Signature]</i>
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
120	QC 6	1 pcs	12/14/18	12/14/18	0.00	0.00	QC 6 - 16	
							QC 6 - 38	
							QC 6 - 42	
							QC 6 - 9	
							QC 6 - 68	
130	Packaging 3-1 - Stock - B4B	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging 3 - 1 - B4B	<i>[Signature]</i>
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
140	QC 21 - SA	1 pcs	12/14/18	12/14/18	0.00	0.00	QC 21 - SA - 16	<i>[Signature]</i>
							QC 21 - SA - 21	

Part Op 100 - -Issue P/O to ARROW TECH MACHINE WORKS ; P/O *641634* -Manufacture RBW6305G01232-3G as
Descriptions: per DWG. -Certificate of Conformity is required
110 - Certificate of Conformity is required

Nov 26. 2018 x1 Rhu GA085

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G01232-3GP	Gimbal Torque Tube Bushing Remover	1 (1 ea)	100-Purchasing	<i>5140229</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6305G01232-3GP	1	0	0



Container No: S140230



Part: RBW6305G01232 - 3G

Job No: 187033

Serial No/Batch: S140230

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/24/18

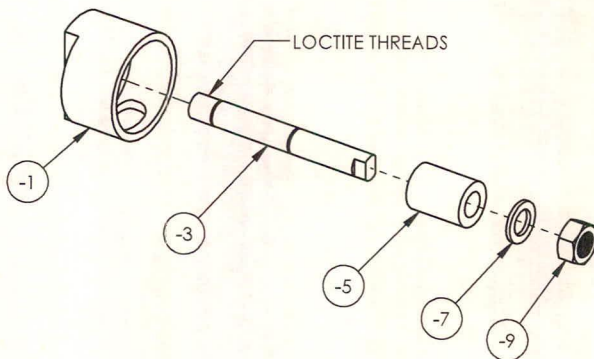
Part Specifications

Specifications could not be found.

Plex 11/26/18 2:37 PM dart.Lussier.Patrick

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		BROKE OUT INTO INDIVIDUAL TOOLS FROM KIT RBW6305G00132-3G.	4/7/2011	RJC	
1		-3 CH'D DIM WAS $\varnothing .375$ IS $.370 +.000 -.005$, ADDED THREAD NOTE $\varnothing .370-.367$. -5 CH'D DIM WAS $\varnothing .381$ IS $\varnothing .375 +.005-.000$.	5/10/2013	CFS	GE
2		-3 CH'D MATERIAL WAS 4140 Q&T IS 4140/4142.	5/6/2014	LA	RJC
3	15-0321	-1 CH'D MATERIAL CALLOUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. -3 DELETED DIMS $\varnothing .370 +.000-.005$ AND $\varnothing .370-.367$. -5 CH'D MATERIAL CALLOUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T.	10/2/2015	RJC	JAG



NOTES:

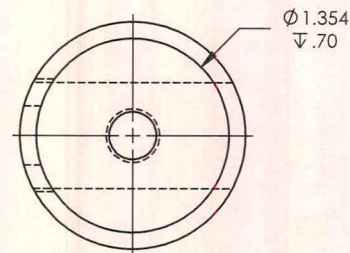
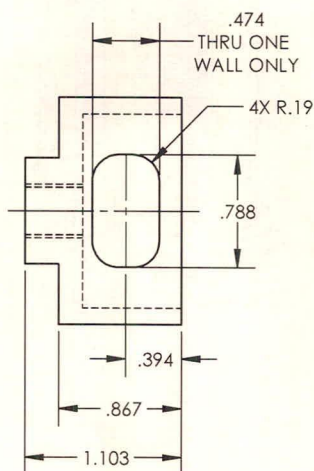
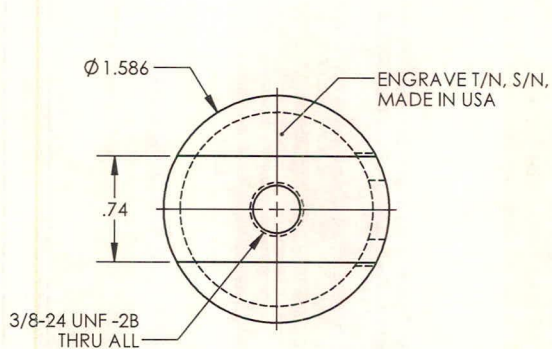
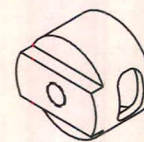
1. REF. AGUSTA T/N: 3G6305G01232.
2. PART OF KIT RBW6305G00132-3G.

DART AEROSPACE	
TITLE GIMBAL TORQUE TUBE BUSHING REMOVER	
DWG NO. RBW6305G01232-3G	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 .X ± .1 ANGLES ± .5° 1. BREAK ALL SHARP EDGES .015 x 45° 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: PERRITT APPROVED: <i>D. Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AGUSTA
SCALE 1:2	DATE 4/7/2011 SHEET 1 OF 4

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RECEIVER	4140 Q&T / 4142 Q&T		2
			-3	1	STUD	4140/4142	$\varnothing 3/8$ X 3-1/8 (MCMaster-CARR #B9351336) MODIFIED	3
			-5	1	SPACER	4140 Q&T / 4142 Q&T		4
		B/O	-7	1	WASHER	STEEL	$\varnothing 3/8$ AN960-616L	1
		B/O	-9	1	HEX NUT	STEEL	3/8-24 UNF-2B AN315-6	1
		B/O	-11	1	LOCTITE 262		AS REQUIRED	N/S

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	15-0321	-1 CH'D MATERIAL CALLOUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T.	10/2/2015	RJC	JAG

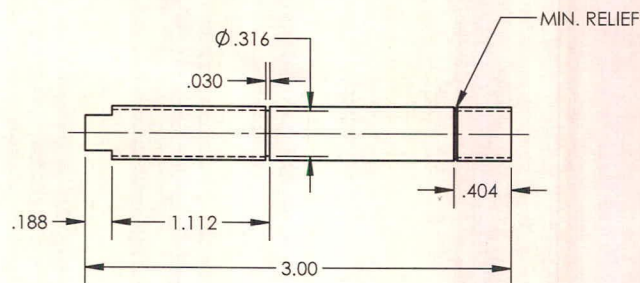
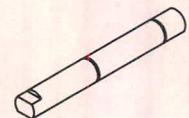


(-1)
RECEIVER

DART AEROSPACE	
TITLE GIMBAL TORQUE TUBE BUSHING REMOVER	
DWG NO. RBW6305G01232-3G-1	REV 3
MAT'L 4140 Q&T / 4142 Q&T	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XX ± .005 FRACTIONS ± 1/8	HEAT
.X ± .01 ANGLES ± 5°	TREAT
.X ± .1	FINISH CAD PLATE YELLOW
1. BREAK ALL SHARP EDGES .015 x 45°	SPEC QQ-P-416, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	AGUSTA
SCALE 1:1	DATE 4/7/2011
	SHEET 2 OF 4

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-3 CH'D DIM WAS Ø.375 IS .370 +.000 -.005, ADDED THREAD NOTE Ø.370-.367.	5/10/2013	CFS	GE
2		-3 CH'D MATERIAL WAS 4140 Q&T IS 4140/4142.	5/6/2014	LA	RJC
3	15-0321	-3 DELETED DIMS Ø.370 +.000-.005 AND Ø.370-.367.	10/2/2015	RJC	JAG

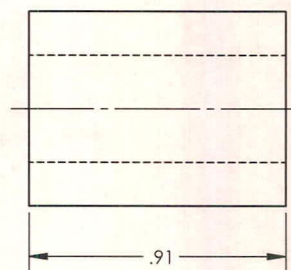
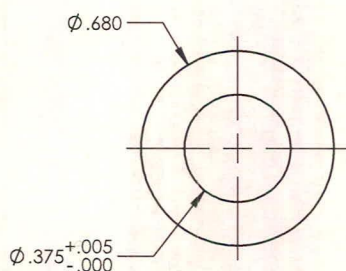
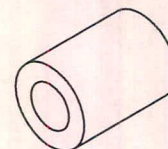


(-3)
STUD

DART AEROSPACE	
TITLE GIMBAL TORQUE TUBE BUSHING REMOVER	
DWG NO. RBW6305G01232-3G-3	REV 3
MAT'L 4140/4142	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>D. Weir</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CAD PLATE YELLOW
.X ± .1	SPEC QQ-P-416, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 1:1	DATE 4/7/2011
SHEET 3 OF 4	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5 CH'D DIM WAS Ø.381 IS Ø.375 +.005-.000.	5/10/2013	CFS	GE
3	1.5-0321	-5 CH'D MATERIAL CALLOUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T.	10/2/2015	RJC	JAG



(-5)

SPACER

DART AEROSPACE	
TITLE GIMBAL TORQUE TUBE BUSHING REMOVER	
DWG NO. RBW6305G01232-3G-5	REV 3
MAT'L 4140 Q&T / 4142 Q&T	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weir</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CAD PLATE YELLOW
.X ± .1	SPEC QQ-P-416, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 2:1	DATE 4/7/2011
SHEET 4 OF 4	



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 350 ✓

Date: 12/11/2018
PO Ref: PO # 041834 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
1 ✓	GIMBAL TORQUE TUBE BUSHING REMOVER	RBW6305G01232-3G ✓
1 ✓	GIMBAL TORQUE TUBE BUSHING INSTALLER	RBW6305G00232-3G ✓

Received by: _____

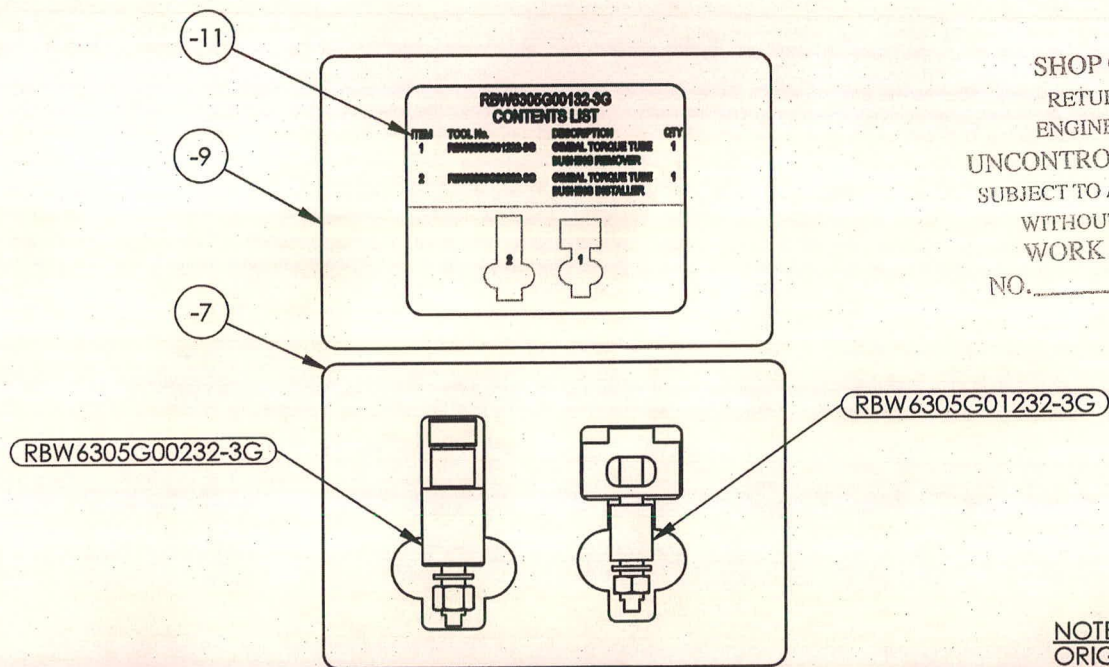
Packaged by: _____

Checked by: _____

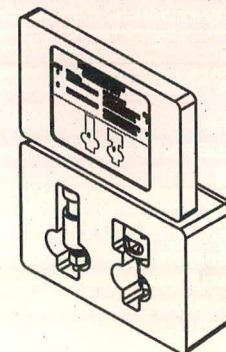
Thank You

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-29 CH'D THICKNESS FROM .31. -31 CORRECTED TOOL NUMBERS.	5/11/2011	RJC	RW
3		-7 CH'D CUTOUTS FROM .87 TO 1.00, AND 1.60 TO 1.62. ADDED FINGER GRAB CUTOUTS. -9 CH'D PLACARD CUTOUT DEPTH FROM .07 TO .10.	10/29/2012	RJC	SE
3A		-7 CH'D DIM WAS R.125 IS R.13. -9 ADDED SECTION A-A, CH'D DEPTH WAS .10 IS .13, CH'D DIM WAS R.375 IS R.38. -11 CH'D DIM WAS .06 IS (.06).	5/5/2014	DPD	RJC
4	15-0322	-9 CH'D DIMS WAS 4.75 IS 4.80, WAS 7.13 IS 7.30, WAS .40 IS .72, WAS 6 IS 4.50, WAS 3.00 IS 3.75 WAS 4X R.38 IS 4X R.25. -11 CH'D DIM'S WAS 2.50 IS 3.75, WAS 6.00 IS 4.50 WAS R.38 IS R.25. ADDED TOOL OUTLINES & ITEM NUMBERS.	10/5/2015	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____



NOTES:
ORIGINAL No. FOR REFERENCE ONLY:
RBW6305G00132-3G = 3G6305G00132

DART AEROSPACE	
TITLE GIMBAL BUSHING KIT	
DWG NO. RBW6305G00132-3G	REV 4
MATL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	APPROVED <i>D. West</i>
SCALE 1:3	DATE 1/13/2009
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	GIMBAL TORQUE TUBE BUSHING REMOVER		RBW6305G01232-3G	1
				1	GIMBAL TORQUE TUBE BUSHING INSTALLER		RBW6305G00232-3G	1
		B/O	-5	1	CASE	PLASTIC	PELICAN #APP1120-E	N/S
		B/O	-7	1	BOTTOM FOAM	Y20 BLACK	2-5/8 X 5 X 7-1/2 I.R. SPECIALTY FOAM	2
		B/O	-9	1	TOP FOAM	Y20 BLACK	23/32X 4-3/4 X 7-5/16 I.R. SPECIALTY FOAM	3
			-11	1	PLACARD	PLASTIC		4



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041834**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO041834
PO Date: 11/23/18
Due Date: 12/14/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Ship To:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	187033	RBW6305G01232-3GP			Gimbal Torque Tube Bushing Remover REV 3	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$940.475/Ea	\$940.48
DAS 68 9-89													
Line Item Note SUB ASSY FOR TOP LEVEL RBW6305G00132-3G (REV4)													
2	187034	RBW6305G00232-3GP			Gimbal Torque Tube Bushing Installer REV 3	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$940.475/Ea	\$940.48
ORDER 7373 06 Jan 2019													
Line Item Note SUB ASSY FOR TOP LEVEL RBW6305G00132-3G (REV4)													
												Grand Total: \$1,880.95	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Plex 11/26/18 2:54 PM dart.Lussier.Patrick



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041834 ✓ Dated: 12/11/2018

Our Order / Job No: 041834-3AWT Order Qty: 1 ✓

Part Name: GIMBAL TORQUE TUBE BUSHING REMOVER

Part Number: RBW6305G01232-3G ✓

Lot Size: N/A Ship Date: 12/11/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6305G01232-3G Rev: 3

Material Size and Type: -1,-3,-5/4140 Q&T STEEL

Material Specifications: STEEL: ASTM A108, ASTM A29

Heat Treatment: N/A

Plating/Finish: ZINC PLATE: ASTM B633 TYPE 1 CLASS 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 12/11/18

Signed: Herman Licht

DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

